



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Page 2

1) Trim off excess flange material  
2) Buff out any light scratches or blemishes  
3) Etch part number and batch number

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**Work Order ID 74970****\*74970\***

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Thursday, October 13, 2011 1:57:26 PM

Item ID: D3269-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bubble Window, RH  
Start Date: 10/13/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 10/21/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

1) Visually inspect for clarity, and proper formation.

0.00 *Sumolix*

170

**\*170\***

Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

*PPP  
74968*

0.00

180

**\*180\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/10/18*  
*MF*  
*11-10-18*

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# Picklist Print

Thursday, October 13, 2011 1:57:26 PM

Page 1

Work Order ID: 74970

Parent Item: D3269-2

Parent Item Name: Bubble Window, RH

Start Date: 10/13/2011

Required Date: 10/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.03.22 New issue KJ/JLM  
IPP B 05.05.09 Added engraving EC  
IPP Rev:06-07-03 As per Rev C JLM  
IPP C 07.11.06 Thermoform in-house DL verified by:EC  
IPP Rev: D 08.07.24 As per New Tool DL.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRYLICS.177		Purchased	No				sf	68.7460		24.122105			
0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SHEET													

Location

Loc Qty

Loc Code

therm

68.746

68.746

116796

24.122105 sq ft.

11/10/12.

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74970
<b>Description:</b> Bubble Window, RH (R44)		<b>Part Number:</b> D3269-2
<b>Inspection Dwg:</b> D3269	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Depth of bubble within tolerances	✓			
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Heger Date: 11/10/17

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	+/-0.25	10.125"	✓			
6.2	0.036 Min	6.055"	✓			
3.8	0.057 Min	0.076"	✓			

Measured by: D. Heger Date: 11/10/17  
 Audited by: S Date: 11/10/17  
 Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/DL	
B	09.10.16	Tolerances revised per Dwg Rev E	KJ	

**Dart Aerospace Ltd**

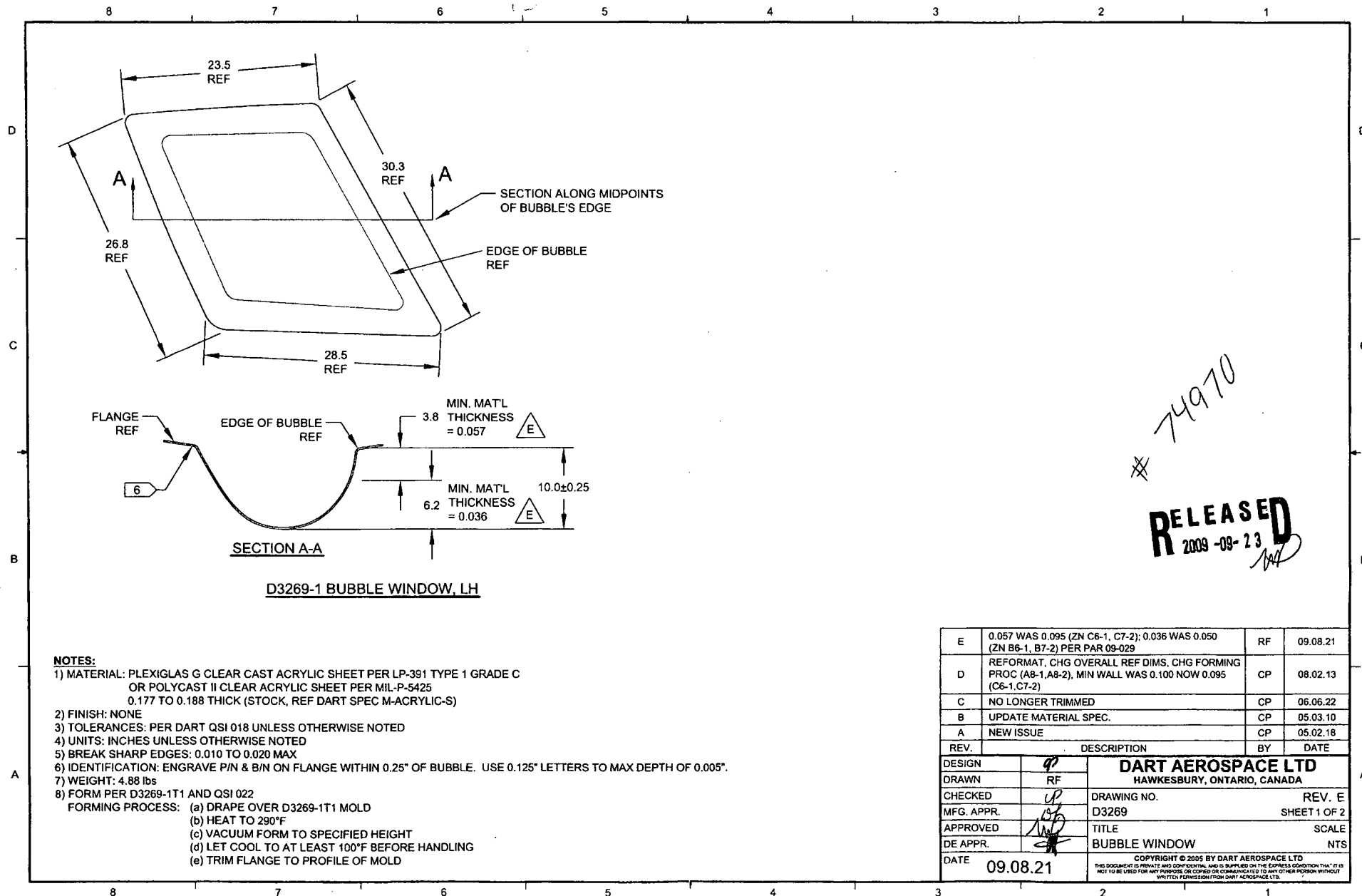
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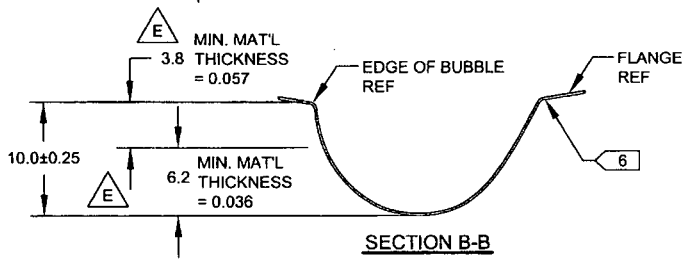
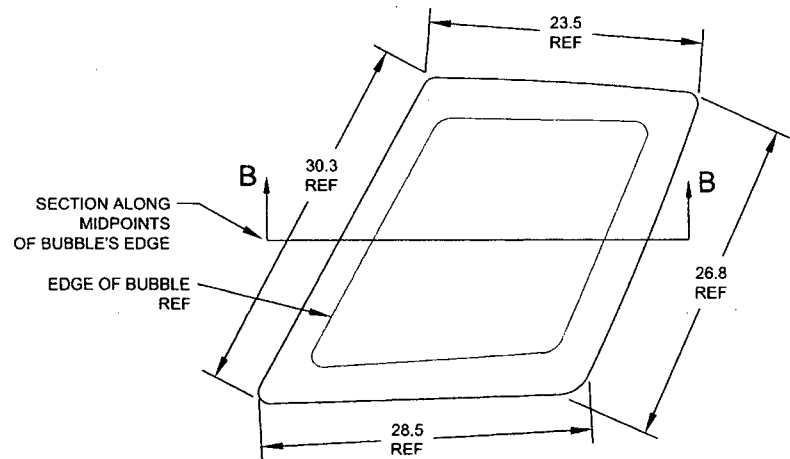
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8 7 6 5 4 3 2 1



D3269-2 BUBBLE WINDOW, RH

# 74970

**NOTES**

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C  
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
0.177 TO 0.188 THICK (STOCK, REF DART SPEC M-ACRYLIC-S)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N & B/N ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005".
  - 7) WEIGHT: 4.88 lbs
  - 8) FORM PER D3269-2T1 AND QSI 022
- FORMING PROCESS: (a) DRAPE OVER D3269-2T1 MOLD  
(b) HEAT TO 290°F  
(c) VACUUM FORM TO SPECIFIED HEIGHT  
(d) LET COOL TO AT LEAST 100°F BEFORE HANDLING  
(e) TRIM FLANGE TO PROFILE OF MOLD

**RELEASED**  
2009-09-23

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. E
MFG. APPR.	AF	D3269	SHEET 2 OF 2
APPROVED	AF	TITLE	SCALE
DE APPR.	AF	BUBBLE WINDOW	NTS
DATE	09.08.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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